

Work Order ID 68344

Tuesday, April 12, 2011 10:07:03 AM



Page 1

Item ID: D3566-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Gasket					
Start Date: 4/12/2011	Start Qty: 30.00		Cust Item ID:		
Required Date: 4/18/2011	Req'd Qty: 30.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>PL</u>	Date: <u>11-04-12</u>	Tooling:	Date:	Run	Start	
	QC: <u> </u>	Date: <u> </u>	SPC (Y/N): <u> </u>	Date: <u> </u>		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3566	Rev C

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3566 <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2- Deburr if necessary								

B1-4-12

36

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B1-4-12

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

11 04 12 36

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3566-1

Accept

Revision ID:

Item Name: Gasket

Start Date: 4/12/2011 Start Qty: 30.00

Required Date: 4/18/2011 Req'd Qty: 30.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: FP-15

0.00



Packaging

Memo

0.00

Packaging

X36 φ 11/04/13

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/13 [Signature]11-09-13
(36)

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Tuesday, April 12, 2011 10:07:09 AM

Page 1

Work Order ID: 68344



Parent Item: D3566-1



Parent Item Name: Gasket


Start Date: 4/12/2011

Required Date: 4/18/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B Added Drain Holes 07-07-09 JLM
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063  NEOPRENE SHEET 0.063		Purchased	No			100	sf	438.7972	0.911	30.36667	33.		

B11-4-12

Location

Loc Qty

Loc Code

MAT052

438.7972

116832

38.7972

117295

400

116832

(36)

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	683414
Description: Gasket		Part Number:	D3566-1
Inspection Dwg: D3566 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.10	+/-0.030	3.103	✓		V HB02	
18.00	+/-0.030	18.00	✓		T HB01	
12.10	+/-0.030	12.10	✓		T	
2.43	+/-0.030	2.431	✓		V	
6.00	+/-0.030	6.00	✓		T	
1.40	+/-0.030	1.404	✓		V	
0.30	+/-0.030	0.303	✓		V	
0.30	+/-0.030	0.301	✓		V	
0.063	+/-0.010	0.057	✓		V	
Ø0.188	+0.005/-0.001	0.188	✓		V	

Measured by: IB	Audited by: ml ml	Prototype Approval:	N/A
Date: 11-4-12	Date: 11-04-12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.26	Dwg Rev updated	KJ/EC/DDC	BE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

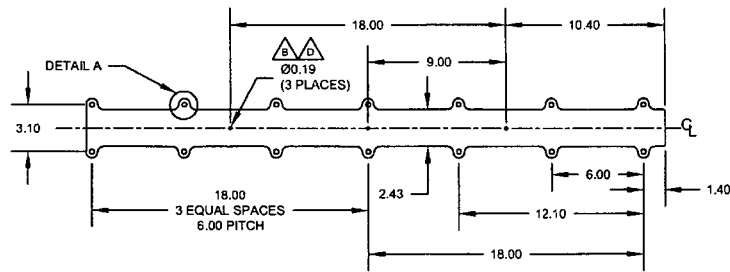
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

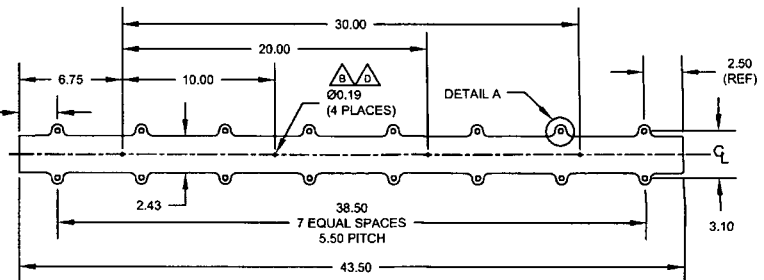
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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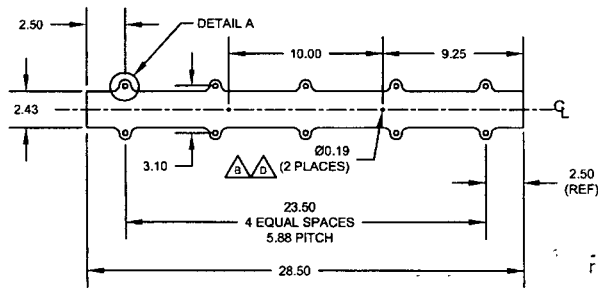
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 08344
11-04-12



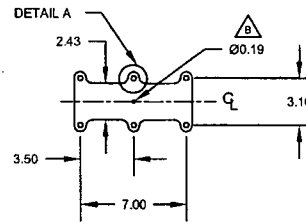
D3566-1 GASKET



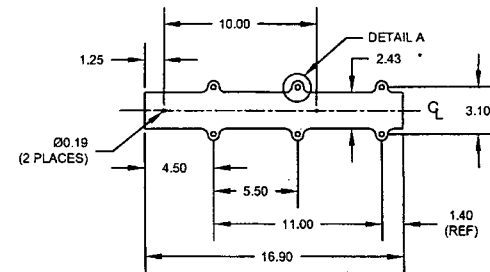
D3566-5 GASKET



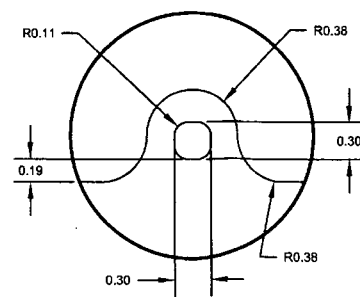
D3566-7 GASKET



D3566-13 GASKET



D3566-15 GASKET



DETAIL A
SCALE 1:1

WEIGHTS:	
D3566-1	0.29 lbs
D3566-5	0.36 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

RELEASED

07.08.21

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: SEE TABLE IN ZONE A3
 - 8) PARTS ARE SYMMETRIC ABOUT CL

C	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;	CB	07.08.21
B	ADD DRAIN HOLES	PH	07.04.17
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3566	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	GASKET	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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